

Date: Tuesday, 11/13/2007 1:34:03 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 35703	
Estimate Number : 11352	
P.O. Number : N/A	Part Number : D33407
This Issue : 11/13/2007 S.O. No. : N/A	Drawing Number : D3340 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 30065	Material : N/A
Written By : <u>JA</u>	Due Date : 11/30/2007
Checked & Approved By : <u>JA 07.11.13</u>	Qty: <u>13</u> Um: Each
Comment : Est: A 05.11.10 Preliminary issue AP/EC Est Rev:B Now on Waterjet 06-09-25 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



12.1355



Comment: Qty.: 0.9335 sf(s)/Unit Total : 11.2014 sf(s)  
1010/1025/A21/6aA SHEET  
(M1010S20GA) .040" THK  
Batch: 106069 13 07-11-15

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D3340  
Dwg Rev: B  
Prog Rev: B

13 07-11-15

13

2-Deburr if necessary

13 07-11-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

13 07/11/16 13

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary  
Form on brake as per Dwg D3340 using Jigs DT and DT

13 07/11/19 13 SB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: R2 Date: 08/11/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:34:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 35703

Part Number: D33407

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 07/11/12 (13)

7.0

POWDER COATING

POWDER COATING



N/10 5642



(13X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M.P. 07/11/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(13)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-11-21

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57499

C. J. M. P. 1

(13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(13)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/20

Job Completion



07-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

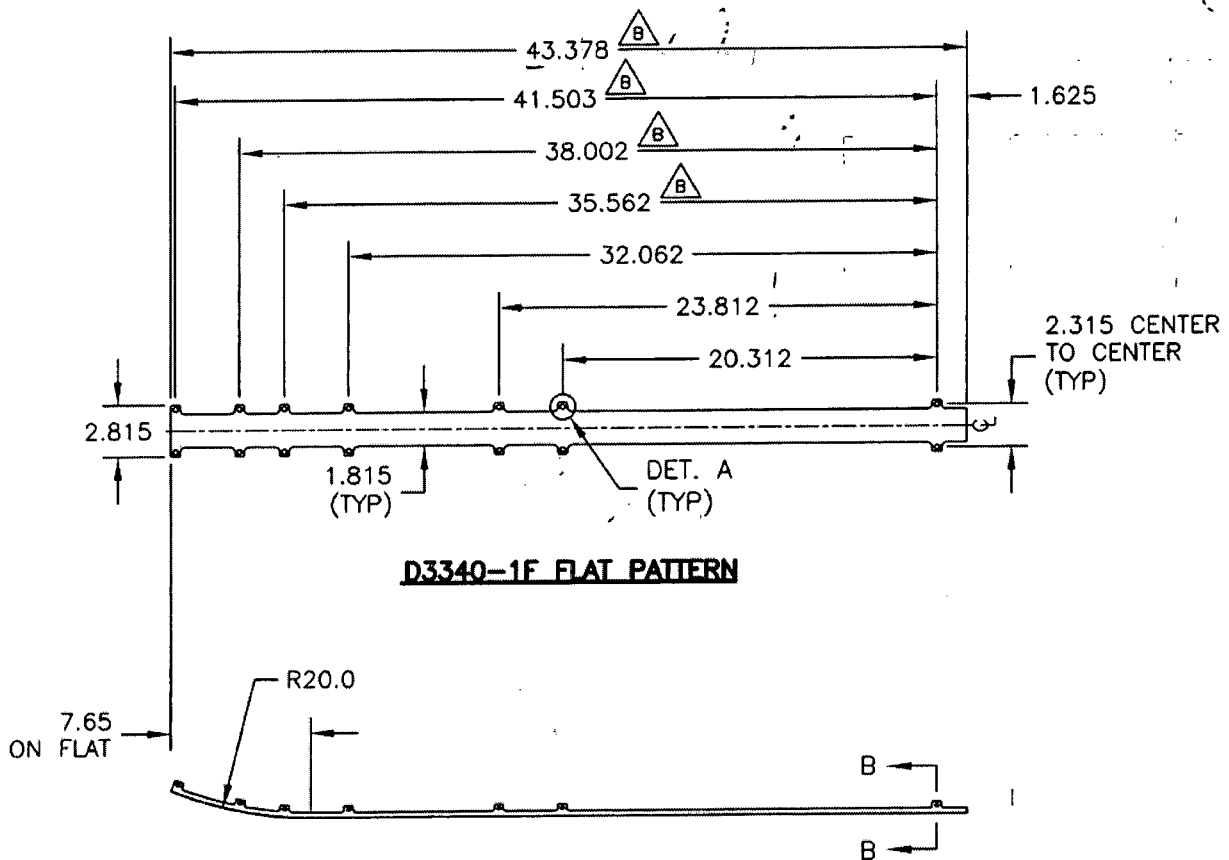
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10
A	05.06.09	NEW ISSUE	
B	05.11.22	ADD DETAIL D, CORRECT FLAT PATTERNS D3340-1/-3/-7/-9/-13/-19/-23	

RELEASED  
05.11.28



### D3340-1 FORWARD SKIDTUBE PROTECTOR

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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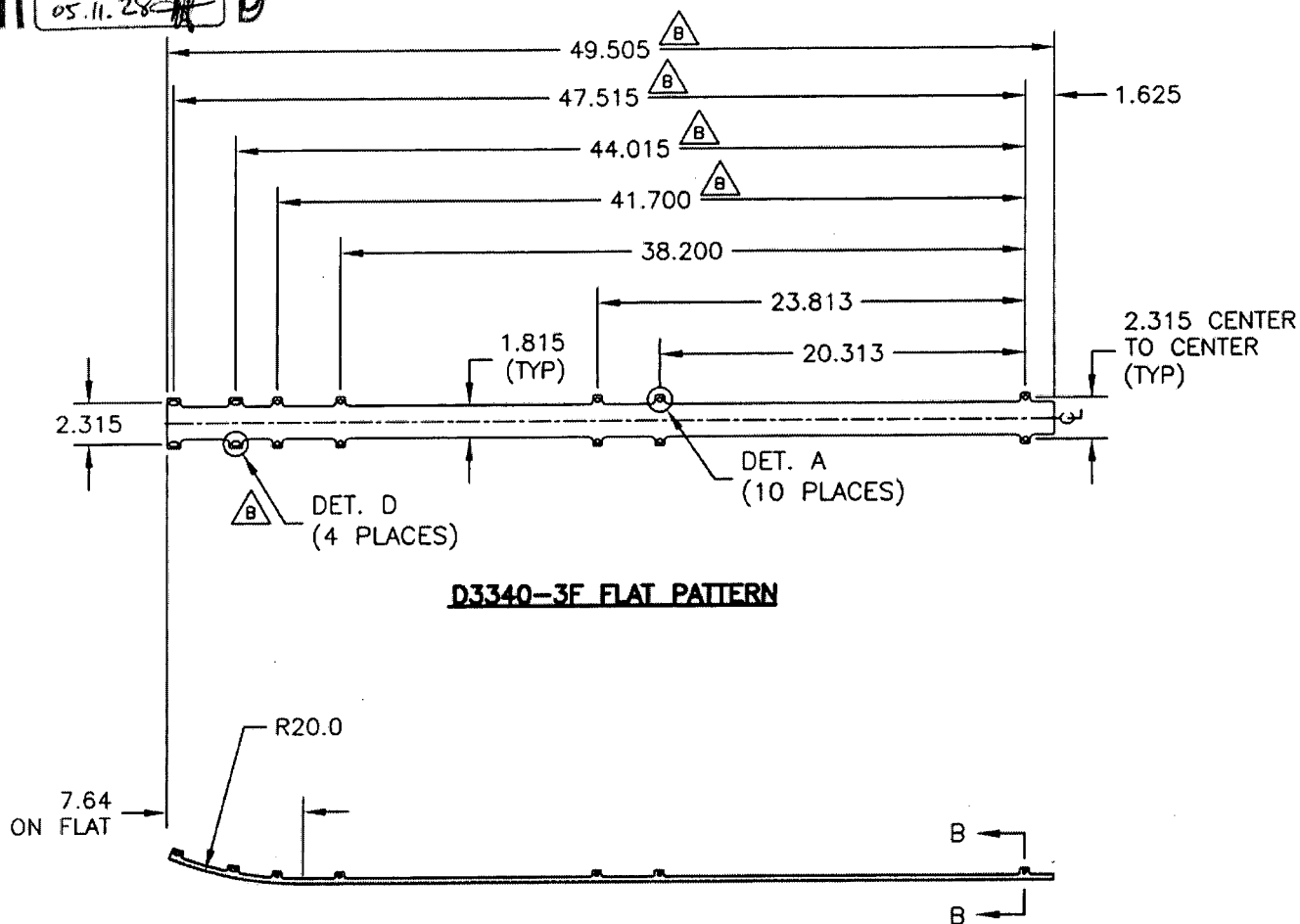
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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05.11.28



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
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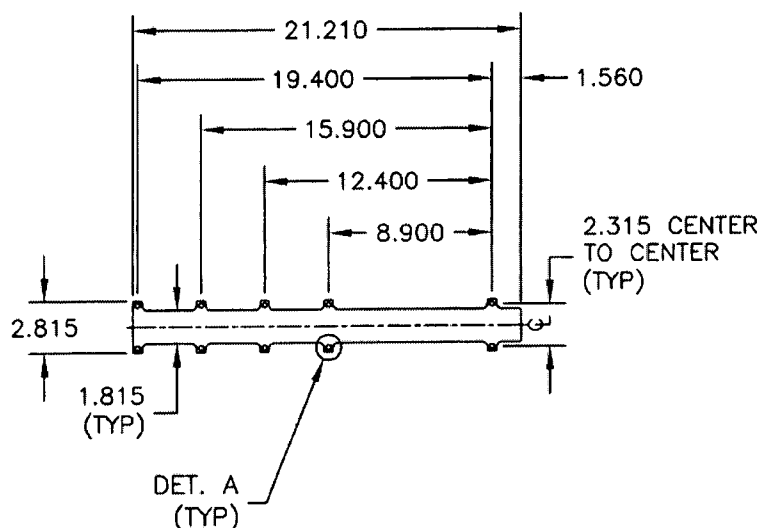
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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**D3340-5F FLAT PATTERN**



**D3340-5 FORWARD SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

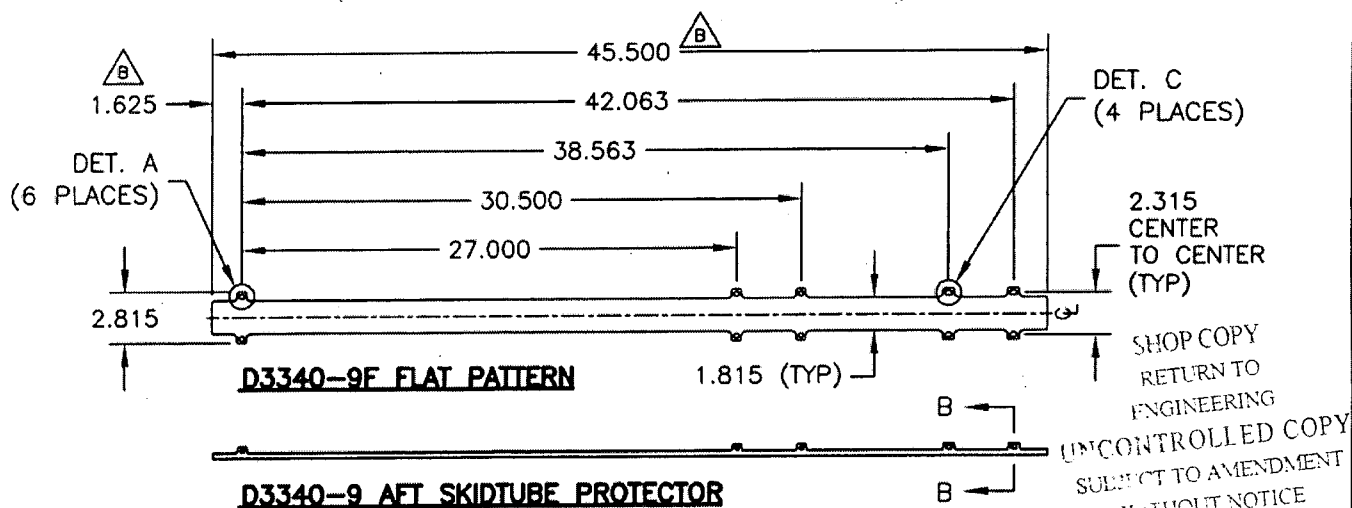
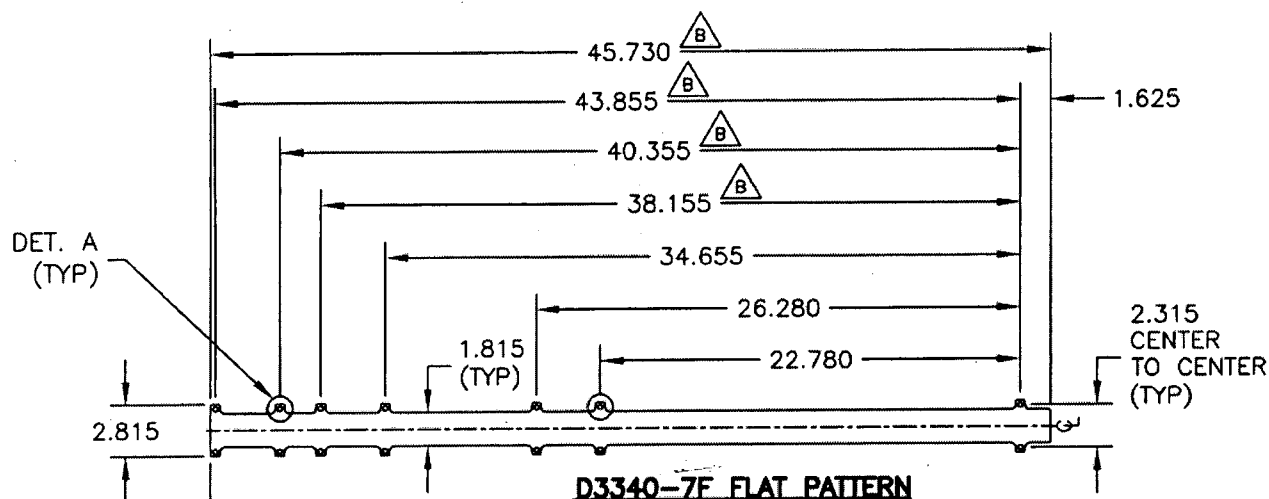
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

**RELEASED**  
05.11.28 *[Signature]*

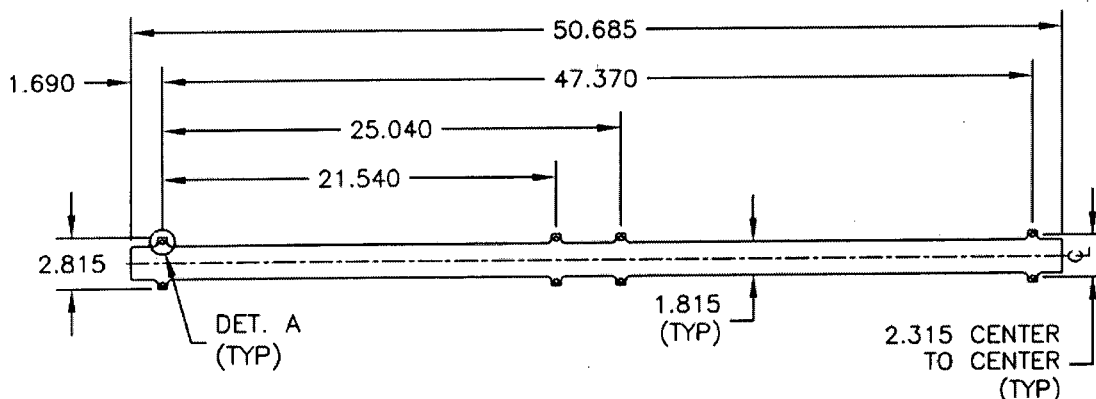
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05.11.28 *[Signature]***D3340-11F FLAT PATTERN****D3340-11 CENTER SKIDTUBE PROTECTOR****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR  
ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)  
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

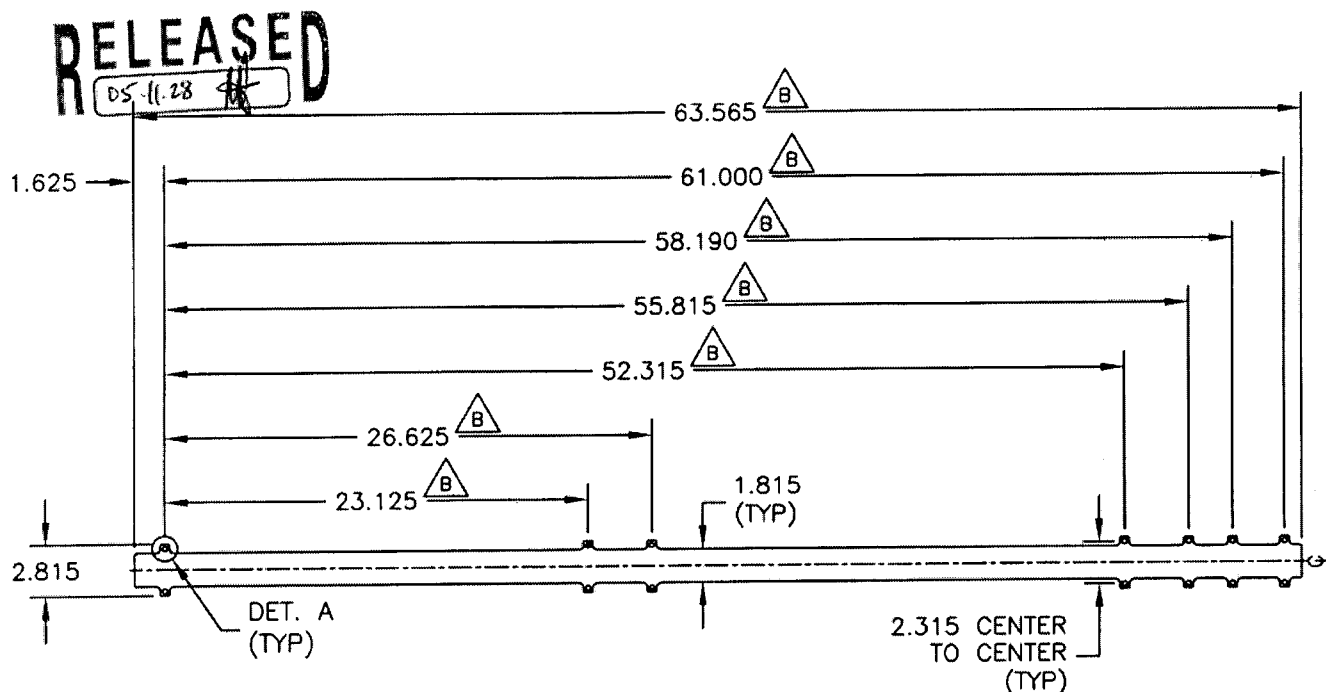
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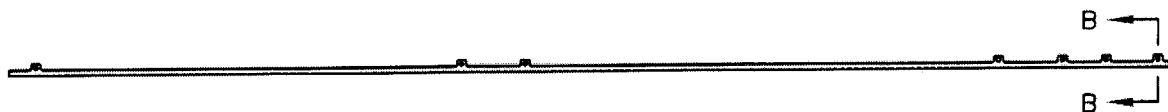
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**D3340-13F FLAT PATTERN**



**D3340-13 AFT SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005-4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

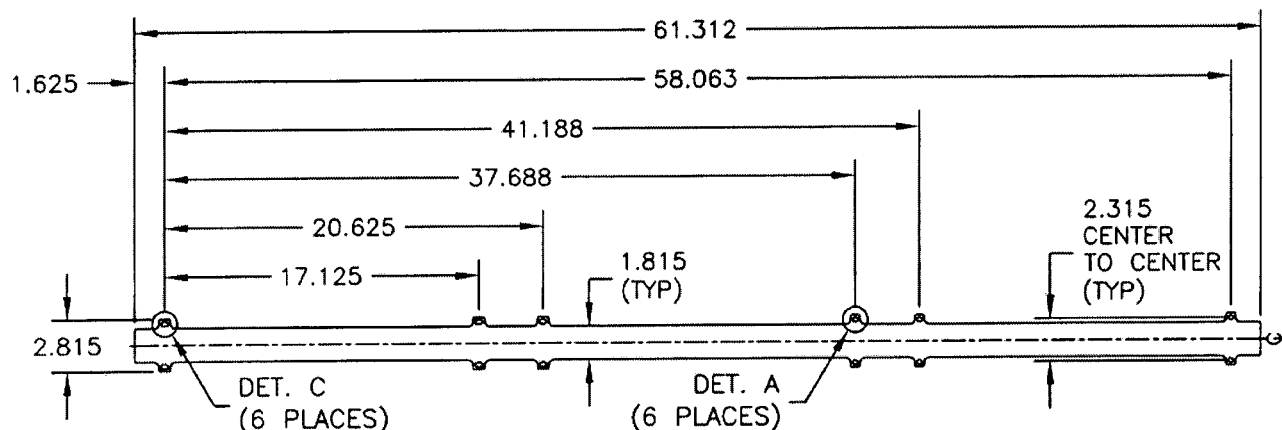
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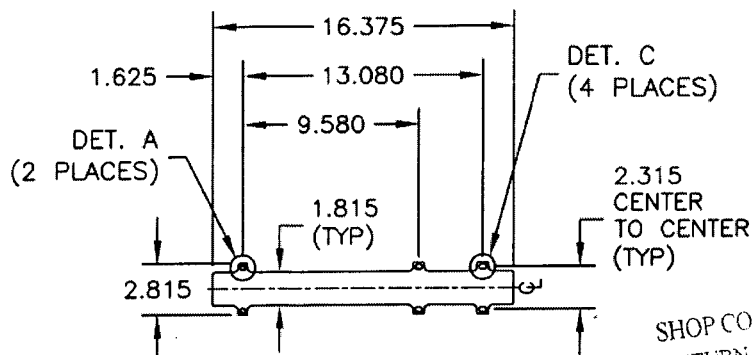
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**D3340-15F FLAT PATTERN**

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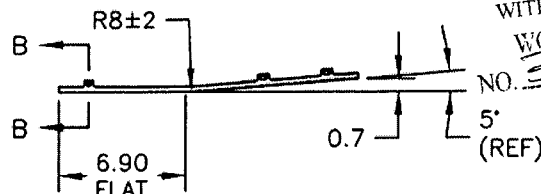
**D3340-15 CENTER SKIDTUBE PROTECTOR**



**D3340-17F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX



**D3340-17 AFT SKIDTUBE PROTECTOR**

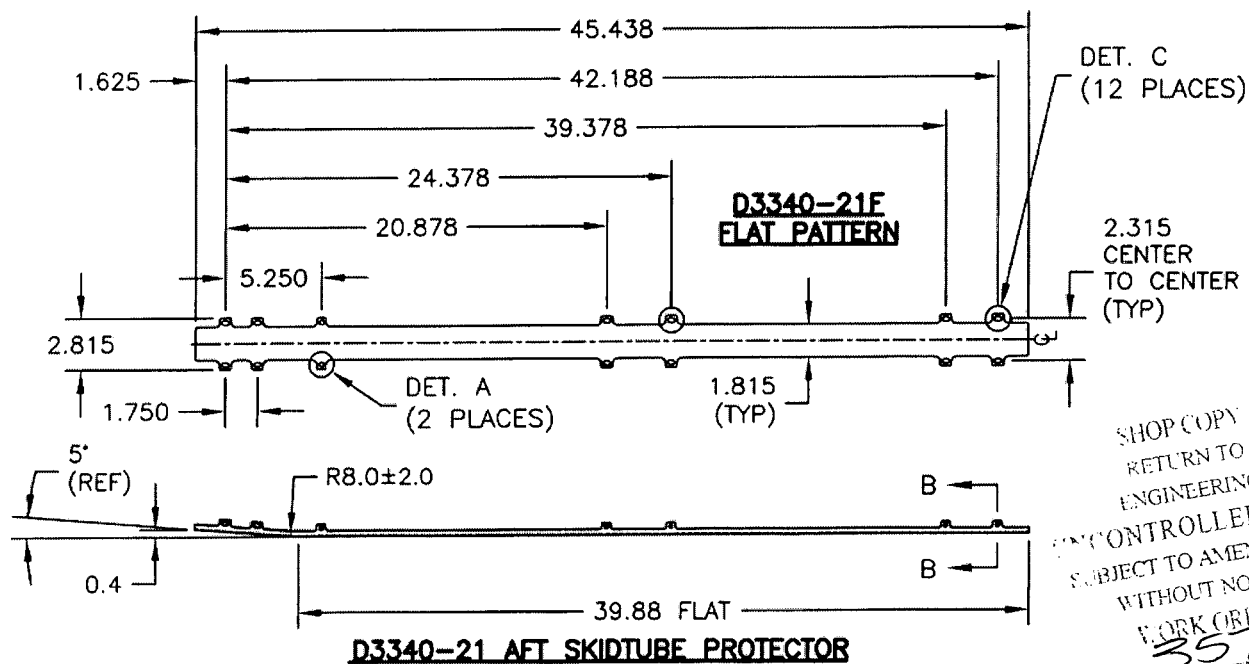
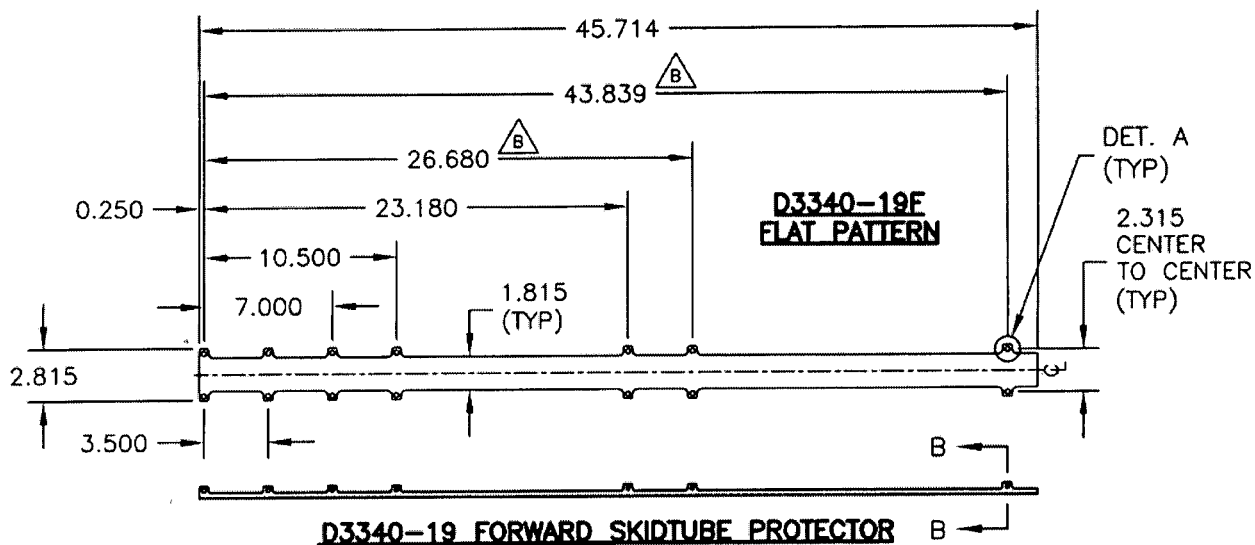
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**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
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- 6) BREAK ALL SHARP CORNERS 0.063 MAX

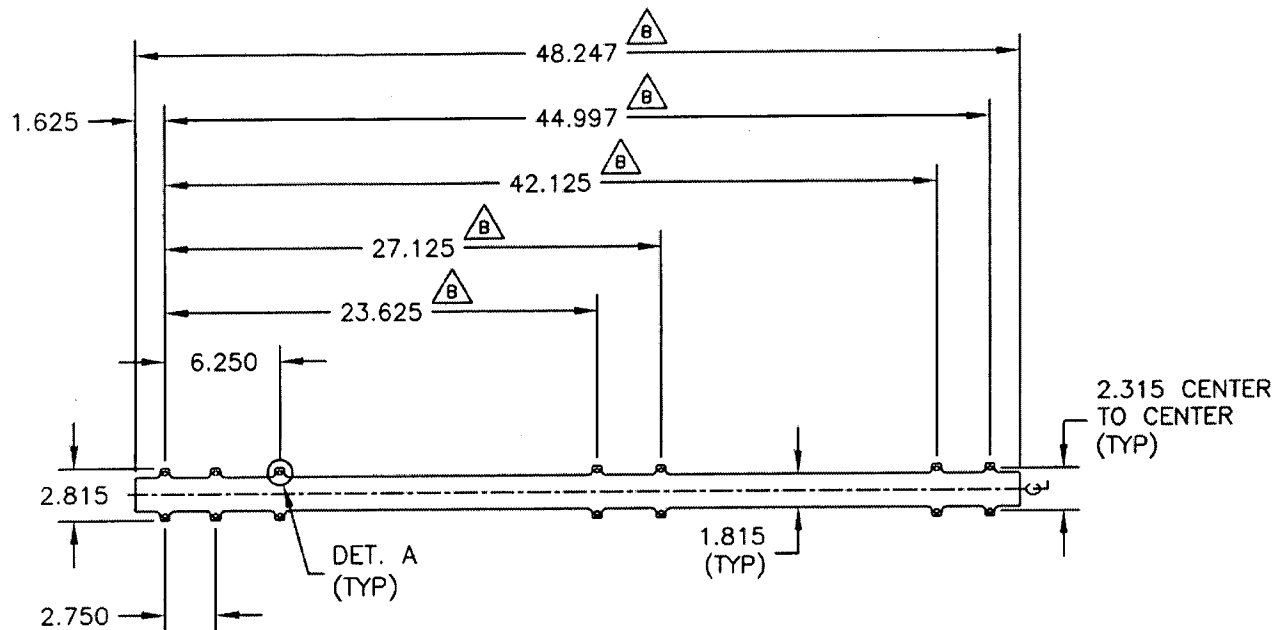
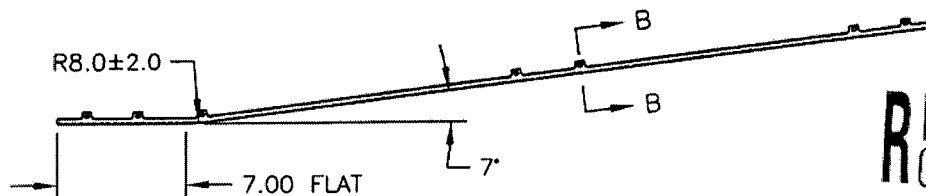
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**D3340-23F FLAT PATTERN****D3340-23 AFT FLOAT SKIDTUBE PROTECTOR****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR  
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COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
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PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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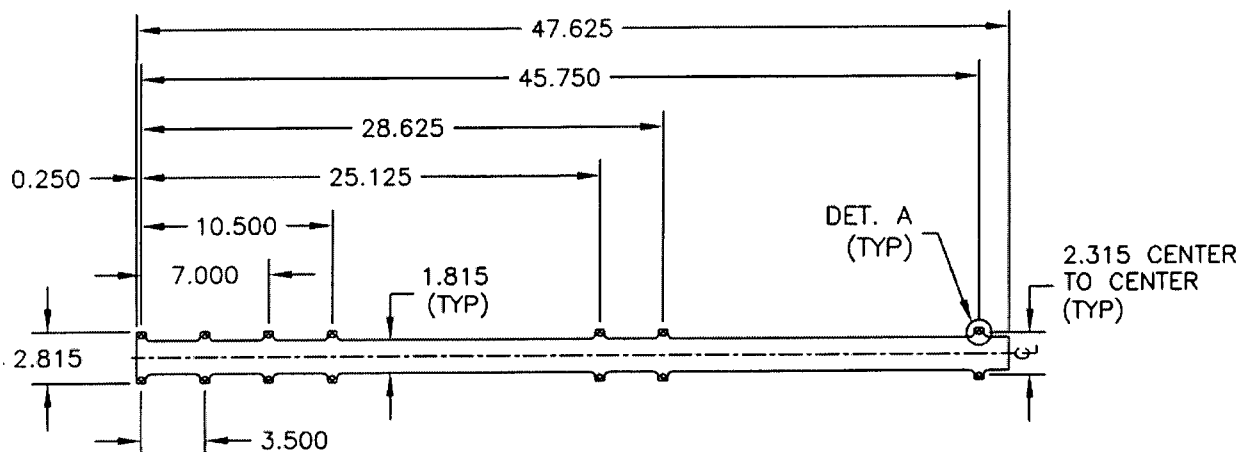
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**D3340-25F FLAT PATTERN**

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**D3340-25 FORWARD SKIDTUBE PROTECTOR**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR  
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CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
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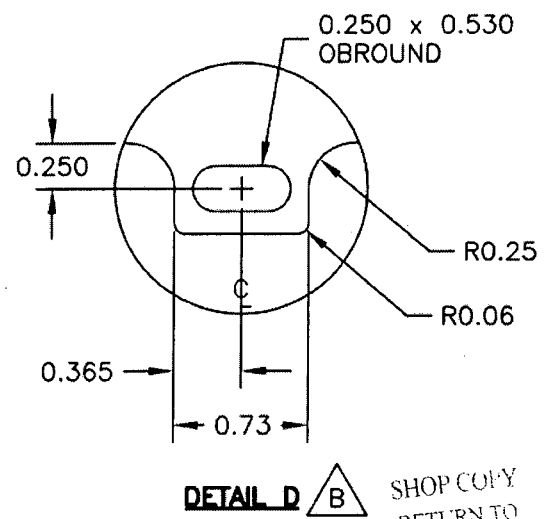
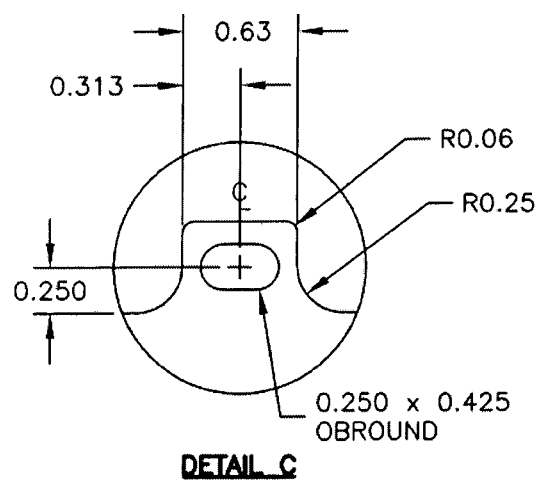
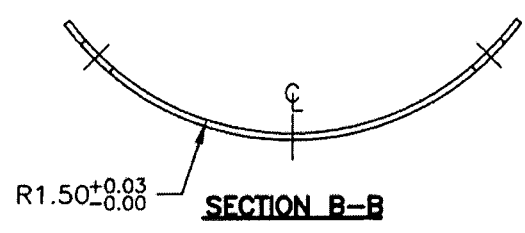
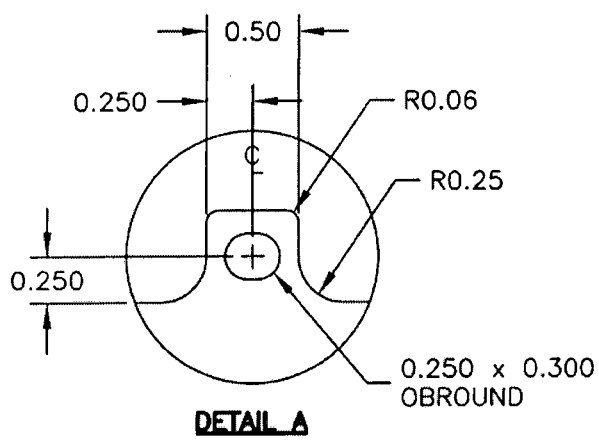
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1

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05-11-28 #



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